

# Work Order ID 65990

Tuesday, February 01, 2011 7:13:49 AM

Page 1

Item ID: D3681-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 2/1/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 50.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-01-2

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3681

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711 & DWG D3681

FOLIO REV: *HA*

DWG REV: *A*

2-DEBURR AS REQUIRED

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65990

Tuesday, February 01, 2011 7:13:49 AM

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Item ID: D3681-1

Revision ID:

Item Name: Spacer

Start Date: 2/1/2011

Start Qty: 50.00

Required Date: 2/7/2011

Req'd Qty: 50.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

BE 11/02/08

x50

130

0.00



Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

BE 11/02/08

x50

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/02/09  
MF  
11-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, February 01, 2011 7:13:46 AM

Page 1

Work Order ID: 65990

Parent Item: D3681-1

Parent Item Name: Spacer



Start Date: 2/1/2011

Required Date: 2/7/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC  
 IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add  
 seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05  
8

Purchased

No

100

f

30.8837

0.34

17.89474



ALUM TUBE .3125 x .058w



11.2-4

Location

Loc Qty

Loc Code

MAT

19.43368421

14559

19.4336842

MAT013

11.45

115894

11.45

116 193

17.916

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

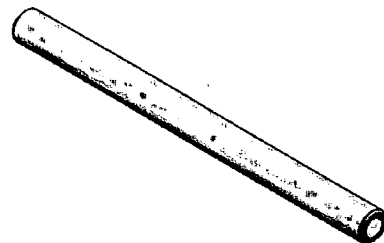
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

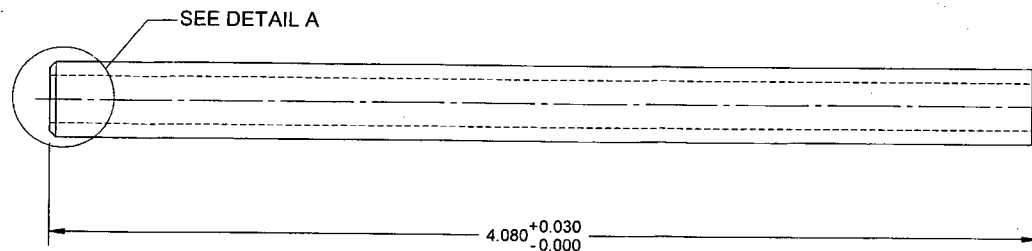
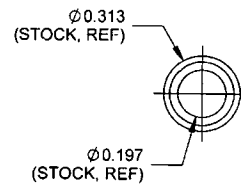
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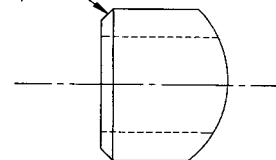




**D3681-1 SPACER**



0.025 X 45°  
CHAMFER  
(TYP)



**DETAIL A**  
(SCALE 4: 1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *65490*  
*2/11-02-1*

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

**RELEASED**  
*07-11-08*

A NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DL</i>		
DRAWN	<i>SC</i>		
CHECKED	<i>MS</i>		
MFG. APPR.	<i>EP</i>		
APPROVED	<i>W</i>		
DE APPR.	<i>H</i>		
DATE	07.11.08		

<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D3681</b>	REV. A
TITLE <b>SPACER</b>	SHEET 1 OF 1
SCALE <b>2:1</b>	

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